

Work Order ID 122614

Tuesday, July 22, 2014 8:41:39 AM

122614

Page 1

Item ID: D3635-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket

Start Date: 7/21/14

Start Qty: 12.00

12

Cust Item ID:

Required Date: 7/21/14

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLSDate: 14-07-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3635

B

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3635

Dwg Rev: BProg Rev: B

2-Deburr if necessary

Rec. 063

DAS

23

9-89

14-09-9

12

0

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

DAS

23

9-89

14-09-9

12

0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 122614

Tuesday, July 22, 2014 8:41:39 AM

122614

Page 2

Item ID: D3635-3

Accept

N900040100

Setup Start

NS1

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(12)

DAS
38
9-89

130

Identify as per dwg & Stock Location

0.00

130

Packaging

Memo

0.00

Packaging

12. 14-9-9

DAS
28
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 14-89-10

MF
14-9-9

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

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Picklist Print

Page 1

Tuesday, July 22, 2014 8:41:38 AM

Work Order ID: 122614

122614

Parent Item: D3635-3

D3635-3

Parent Item Name: Gasket

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-24 ec Verified By:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MNEO60S.063

Purchased

No

110

sf

575.7901

0.021

1

DAS
23
9-89

MNEO60S 063

NEOPRENE SHEET 0.063

14-09-9

Location

Loc Qty

Loc Code

MAT052

575.7901

M126546

27.1

M128266

12.29

M128339

536.4001

128339

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	122614
Description: Gasket		Part Number:	D3635-3
Inspection Dwg: D3635	Rev: A <i>Full</i>	Page 1 of 1	

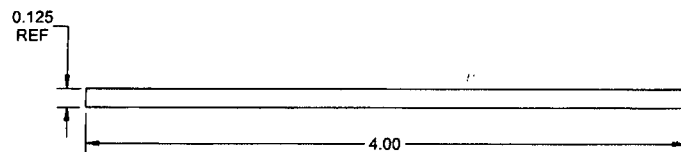
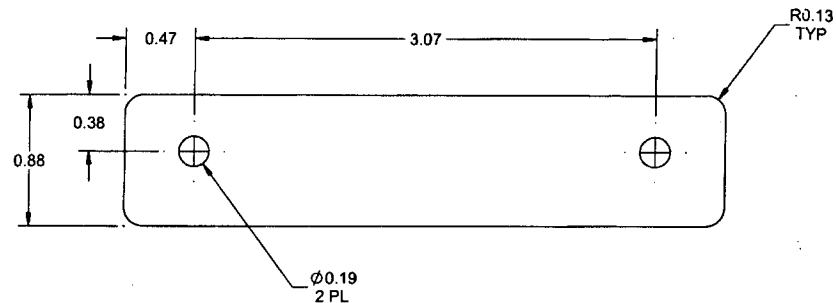
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

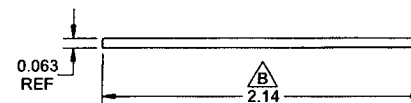
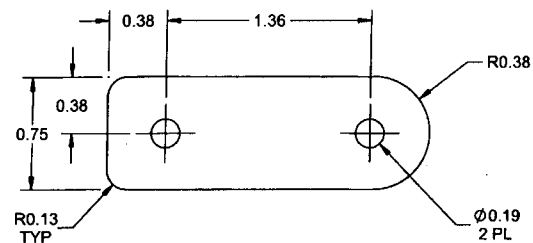
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.26 N/A	+0.006/-0.001					
0.19 ✓	+0.005/-0.001	0.19"	-		✓	Jkmo1
2.94	+/-0.030					
2.14 ✓	+/-0.030	2.14"	✓		✓	
0.38 ✓	+/-0.030	0.38"	-		✓	
0.40 N/A	+/-0.030					
0.75 ✓	+/-0.030	0.75"	✓		✓	
0.80 N/A	+/-0.030					
0.063 ✓	+/-0.010	0.063"	-		✓	
1.36	+/-0.030	1.36"	-		✓	
R.13	+/-0.030	0.13"	-		RG	

Measured by:	DAS 23 9-89	Audited by:	DAS 36 9-89	Prototype Approval:	N/A
Date:	14-09-9	Date:	14-8-8	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	<i>[Signature]</i>



D3635-1 GASKET



D3635-3 GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122614 ML5
1407-23

RELEASE
2012-05-28

NOTES:

- 1) MATERIAL: D3635-1 - BLACK 60 DUROMETER NEOPRENE SHEET 0.125" THICK (REF. DART SPEC. M-NEO60-S.125)
D3635-3 - BLACK 60 DUROMETER NEOPRENE SHEET 0.063" THICK (REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01lbs EA

B	REFORMAT DRAWING; D3635-3 GASKET MODIFIED (REF. PAR 11-115)	AP	12.03.27
A	NEW ISSUE	MB	07.08.01
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3635 GASKET SHEET 1 OF 1 SCALE NTS COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.27		